Work Orde <i>May-13-13 1:13</i>		01748		*101	1748*						Page 1
Revision ID:	D2022-101 Spacer			Accept	*N900	040	100)* s	etup Star Stop	1 71	S1*
	5/10/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:				I V	
Approvals:	Process Pl	an: MCJ	Date: 13-05-14	Tooling: _	Dε	nte:		R	tun Star	1/7	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Stop	` *N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr			V						
D2022	rev	97.01.14									
*100				0.00	· <	3-6.5	۷	41			OAS 04 9-89
Hardinge Hardinge CNC Latho	e Small	Memo Note:257" d 1-Turn as pe FOLIO REV DWG REV: 2-Deburr as	er folio FA206 & dwg	0.00							
*110		QC2- Inspect parts off m	achine FAI/FAIB	0.00	\3	2-C-2		4/			(04 04 8-8
QC		Memo	•	0.00		•					4-01
Quality Control											

DQA: Date:	
------------	--

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	•							•		QA Closed:	Date	e:
Work Order	···				DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Part No					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab		Water Jet	Engineering Quality
NCR No	0				Use-as-is Work Order Update]		noforming	Finishing Composite	Kec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
опаррточеа		1	<u> </u>		F	AUL	T CATE	GORY				1
Landing	g Gear				General			* * *				
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped at n Strip in n Bend Vaves in E equence	Tube Extrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of S	on Incomplete ions Incomplete/ nance iled d Calibration Sequence	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ct ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tub	oe o		Folio	1 1	Outside	Dimensions				

Work Ord <i>May-13-13 1:1.</i>		101748		*101748*									Page 2		
Item ID: Revision ID: Item Name:	D2022-10 Spacer	01			Accept	*N900	040	100)*	Setup	Start Stop	IVI	S1*		
Start Date: Required Date: Reference:	5/10/13 5/31/13	Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*		Cust Item I Customer:	D:		·						
Approvals:	Process QC:	Plan:	Date:_		Tooling: _ SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center II	D	Operation Description QC8- Inspect parts - sec	ond check		Set Up/ Run Hours	Tool ID	Tool #	Code	Accep Qty	Qt	•	Reject Number	Insp. Stamp		
120 QC Quality Control		Мето			0.00	Se	113-06	,-03	411		2_				

140

130

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

0.00

Quality Control

130

Packaging

Packaging

0.00

MLJ 13-06-05

Memo

Memo

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Date	e:
Work Orde	r .				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
					·							
Root					ption of work order update		nitial		tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier												
Training Unapproved												
<u>' </u>		•			F	AUL	T CATE	GORY				
Landin	g Gear				General							<u></u>
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Torque W			n	Drawing	\vdash		Calibration				
ļ	Turning S Wave/Tw			-	Finish Folio	-		Sequence Dimensions				

May-13-13 1:13:22 PM

Work Order ID:

101748

Parent Item:

D2022-101

Parent Item Name:

Spacer

Start Date: 5/10/13

Required Date: 5/31/13

Start Qty: 40.00

Required Qty: 40.00

Comments

IPP D02 03 07 Now made in house

MAT

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	82.3340	0.03	1.2			
6061-T6 Round Bar .750"													
				Location		Loc Qty	Lo	c Code					- /

125552

82.334 82.334

1.1/2 B.C-2

NCR:	Yes	/	No

											DQA:	Date:		
NCR: Y	es	/ No				WORK ORDER NON-	·COI	NFORI	MANCE / UPDATE		•			
											QA Closed:	Date:		
Work Orde	ri:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N		,				Rework Scrap		1	Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality Other	
NCR N	lo	•				Use-as-is Work Order Update			noforming Finishing Large Fab Composite	-	Rec/Stor	e/Packaging Supplier	Other	
Root					Desci	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	-	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
oc/Data	_	ļ				•							·	
quip/Tooling	4													
perator	_													
/laterial	_													
etup	_												·	
Other	\dashv													
rocess	-									- 1		. *	}	
upplier raining	\dashv													
Inapproved	\dashv									Ì				
mapproved 1						· · · · · · · · · · · · · · · · · · ·	FAUI	T CATE	GORY				1	
Landir	ng Ge	ear				General						· -, - , -		
ſ		Bending			Γ	Bend		Grain			Ovalized		Pressure/Forced	
ļ	\Box	Centre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorrec	t 🗌	Weld	
		Crushed/C	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination					Mainte	enance		Part Moved					
	Heat Treat Countersink					Mislabe	eled	-	Positioned W	_	-			
	Inspection Strip in Tube Cut Too Short					Misread	1		Power Loss/S	Surge	Other			
Ripples in Bend Drill Holes					_	Offset		_						
	_	Torque W		xtrusion	ր	Drawing	L	4	Calibration	_				
	—;	Turning Se				Finish	\perp	Out of S	Sequence	_				
i	١	Wave/Twi	ist in Tub	e	1	Folio	1	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101748
Description: Spacer	Part Number:	D2022-101
Inspection Dwg: D2022 Rev: -		Page 1 of 1

	FIRST	ARTICLE II	NSPECTI	ON CH	ECKLIST		
	x	First Arti	cle _	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
0.226	+/-0.010	226			FR . 07		
0.032 x 45°	+/-0.010	.029		_			
0.740	+/-0.010	. 740					
Ø0.257	+0.005/-0.000	, 260					
						· ·	
						-r	
easured by:	04 04	Audited by:	St		Prototype Appro	val:	N/A
Date:	13.6.2	Date:	13-06.	03		ate:	N/A

Measured by: 04	Audited by:	Prototype Approval:	N/A
Date: 13.6.2	Date: 13-06-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.05	New Issue	KJ/JLM O	

RELEASED

.032 × 45°

CHAMEGE TYP.

101748 MUS 13-05-14

D2022-101

DRILL F (257) DIA IN -101 DRILL P (323) DIA IN -103

MAT'L: ALUMINUM 6061-TG (00-D-225/8)

(SP V GE

	w ~ ?							Ø.	5055-10	<u>*3</u>	38.0%	ER 5/16	ALUM 6061-76	8/025-4-05
								D.	2055-10	1	280	CER 14	ACUM 6061-T6	3/025-4-00
	T	PEVISION			RIVET CODE SHAL	L BE PER NAS 523	OTY, REQUIRED	·	PARTNO.	ITEM	DE	SCRIPTION .	MATERIAL	SPEC_/VENDOR
	I	DRAWN	THE DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPLIS OR COPIED ON COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DATE HERO.		N BASIC CODE DIA DASH NO HEAR SIDE FINEAD FAR SIDE	DIA DASH NO	APPROVAL		CONTRACT NO.	: >		מאת	OT AFRO ACCUSES	DTTG T146
		APPROVED		4.00		1.	DRAWN		DATE	DAK	T AERO ACCESSO	KIEZ INC		
		DESCRIPTION	RECUREMENTS — UNLE	S OTHERWISE SPECIFIED	DEDMINE DIGITENO OF SHEETS	LENGTH DASH NO.			8500re		كالمر	COTENI		
	1.	DESCRIPTION	* DINNERSIONS ARE IN INCHES - 2. SURFCE ROUGHRESS ***.	1. TOLERANCES - JOI 2 030 300 4 010	BASIC CODES		-		BRAGLEY		O Oak			
and the	CHANGE		3 PEMOVE SHAPP EDGES OF BHAX. 4 THEADS PER MR - 5 - 2742 8 HOLES PER MND 10387	2 ANGLES 1 W 2 PARALLELISM 1 DO25 4 ECCHITRICITY 1006 MAX 5 SYMMETRY ARCHIT	BJ+MSJO470AD BR+MSJ9476AD				STRESS			TITLE	SPACER	25
				ALL M/C CENTRE LINES .005		l - ,		1. 4				COOE	max D2022	> **
			REPORT	ALL DISCREPANCIES — DO NO	T SCALE			:	CLIENT		·		ENT TITLE SHIT	(OF)

D2027